

Work Order ID 84052

Tuesday, May 01, 2012 2:36:20 PM

84052

Page 1

Item ID: D4418-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Lug

Stop

NS2

Start Date: 5/1/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/10/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *12-05-01*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4418

A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to 3.125"

OK 12/05/08

6

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB0063

DWG REV: *A*

FOLIO REV: *AA*

JK 12-05-09

6

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 84052

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Tuesday, May 01, 2012 2:36:20 PM

Item ID: D4418-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Lug
 Start Date: 5/1/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/10/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
145 Powdercoat Powder Coating <i>M121134</i>	Memo <i>START: 7:45 OVEN-T: 3200F FINISH: 8:15</i>	0.00				<i>BK</i>			<i>M-L 12/5/10</i>
146	QC3- Inspect Part Finish	0.00							
146 QC Quality Control	Memo	0.00				<i>C</i>	<i>φ</i>	<i>B12510.</i>	
180	Identify as per dwg & Stock Location: <i>464</i>	0.00							
180 Packaging Packaging	Memo	0.00				<i>Q</i>		<i>12/5/10</i>	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Tuesday, May 01, 2012 2:36:20 PM

84052

Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Step Lug

Start Date: 5/1/2012 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 5/10/2012 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

Accept
Qty

Reject
Qty

Reject Number

**Insp.
Stamp**

190

QC21- Final Inspection - Work Order Release	0.00
---	------

0.00

190

QC

Memo

0.00

Quality Control

ME
12-05-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 01, 2012 2:36:20 PM

Page 1

Work Order ID: 84052

Parent Item: D4418-1

Parent Item Name: Step Lug

Start Date: 5/1/2012

Required Date: 5/10/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 11-07-12 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.500 6061-T6 Bar 2.00 x 3.50		Purchased	No			100	f	14.3483	0.26	1.6421053			

Location

Loc Qty

Loc Code

MAT009

14.3483

112764

0.7284

118182

11.4527

→ 118641

2.1672

2.1672 and 12/05/08

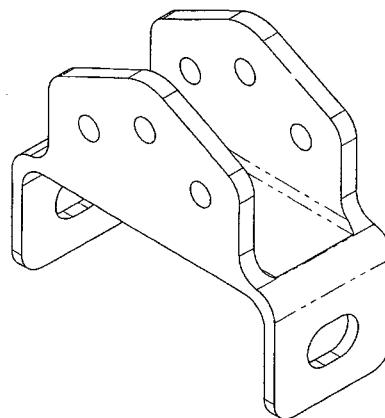
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



D4418-1 STEP LUG

#84052

RELEASED
2011-07-28
JW

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4418-1" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.20 lbs

A		NEW ISSUE		AJS	11.07.04
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A		
MFG. APPR.	<i>[Signature]</i>	D4418	SHEET 1 OF 2		
APPROVED	<i>[Signature]</i>	TITLE	SCALE		
DE APPR.	<i>[Signature]</i>	STEP LUG	NT		
DATE	11.07.04	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			

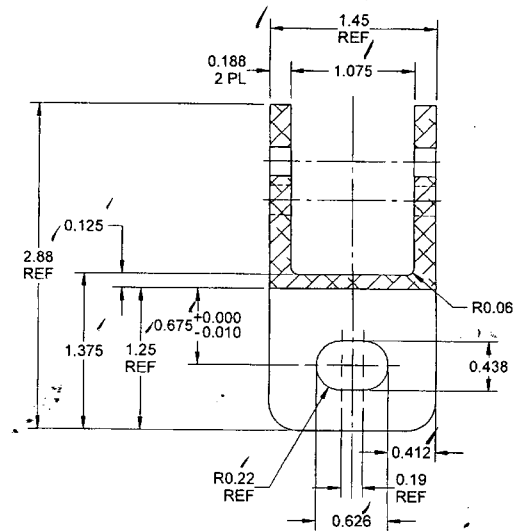
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



SECTION A-A C6-2

RELEASED
2011-07-28

DESIGN	AJS	DART Aerospace LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4418 TITLE STEP LUG COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. A
DRAWN	AJS		SHEET 2 OF 2
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE 11.07.04			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 84052
Description: Step lug		Part Number: D4418-1
Inspection Dwg: D4418	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.257	+ .004 - .001	.258	✓		Vern	SL-10
.125	± .010	.125	✓		"	"
3.045	± .010	3.045	✓		"	"
.700	± .010	.699	✓		H-G	
.78	± .030	.782	✓		Vern	SL-10
1.13	± .030	1.126	✓		"	"
.342	± .010	.340	✓		H-G	
5.25	± .030	.25	✓			
6.50	± .030	.50	✓			
2.40	± .030	2.400	✓		Vern	SL-10
3.30	± .030	3.295	✓		"	
.45	± .030	.447	✓		H-G	
1.45	± .030	1.450	✓		Vern	SL-10
1.075	± .010	1.075	✓		"	"
.188	± .010	.188	✓		"	"
.125	± .010	.126	✓		H-G	
2.88	± .030	2.876	✓		"	
1.375	± .010	1.375	✓		Vern	SL-10
1.25	± .030	1.249	✓		H-G	
.675	± .010	.670	✓		"	
.626	± .010	.625	✓		Vern	SL-10
.412	± .010	.413	✓		"	"
.438	± .010	.438	✓		"	"
5.06	± .030	.060	✓			

Measured by: SL	Audited by: <i>aml</i>	Preliminary Approval:
Date: 12/05/09	Date: 12/05/09	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15